



ISTANBUL  
NISANTASI  
UNIVERSITY

# 1<sup>st</sup> INTERNATIONAL HEALTH SCIENCES CONGRESS

 May 7-9, 2026

 İstanbul / TÜRKİYE



PROCEEDINGS BOOK



EDITOR

Prof. Dr. Fadime ÇINAR

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**SESSION-1/HALL-10**



**İSTANBUL**



**UZBEKISTAN TIME: 10:30-12:30**

**CHAIR:** Asst. Prof. Dr. Mamatbuvayev Sanjarbek

| Author(s)                                                                                                        | Affiliation                                                                                                                   | Title                                                                                                                           |
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## PETROLEUM COKE AND ITS PROPERTIES: PHYSICAL-CHEMICAL ANALYSIS AND SANITARY-HYGIENIC IMPACT ON WORKERS' HEALTH

**Mamatova Shaxnoza Iloxomovna**

Fergana Medical Institute of Public Health, Assistant

ORCID: <https://orcid.org/0009-0007-3512-2349>

### Abstract

This study presents a comprehensive, in-depth investigation into the physicochemical properties, structural classifications, and diverse industrial applications of petroleum coke generated throughout advanced crude oil refining processes. Focusing specifically on the operational environment of the Fergana Oil Refinery (FOR) as a primary industrial case study, the research thoroughly examines the origin, dispersion mechanisms, and technological sources of coke dust emissions. Furthermore, it evaluates the complex hygienic, toxicological, and environmental hazards associated with prolonged occupational exposure. Analytical data and instrumental measurements substantiate that airborne concentrations of coke dust frequently exceed established maximum allowable thresholds, directly contributing to the impairment of workers' physiological functions and triggering severe respiratory and systemic pathologies. Consequently, the paper emphasizes the critical imperative for implementing modern technological modernization, closed-loop production cycles, advanced filtration systems, and rigorous occupational health safeguards.

**Keywords:** petroleum coke, coke dust emissions, thermal cracking, pyrolysis, carbon matrix, industrial hygiene, occupational toxicology, environmental safety, occupational diseases, preventive measures.

### INTRODUCTION

In recent years, diversifying the fuel and energy sector, utilizing resources efficiently, and ensuring healthy working conditions in modern industrial enterprises have remained among the most pressing issues. Crude oil refining technology plays a vital role in enriching energy resources and manufacturing various chemical products. However, due to the thermal decomposition of heavy fractions, these processes not only produce a solid carbon-based substance known as petroleum coke, but also generate harmful airborne factors, specifically coke dust, which poses a serious threat to workers' health. The main objective of this study is to examine the physicochemical properties of petroleum coke and evaluate the key hygienic and ecotoxicological factors using the example of the Fergana Oil Refinery.

### MAIN BODY

Petroleum coke is a solid carbonaceous product generated through the high-temperature thermal cracking or pyrolysis of heavy residual crude oil fractions at operating temperatures ranging from 500 to 550 degrees Celsius. Industrial processing primarily relies on technological methods such as delayed coking and fluid coking. Based on processing stages and applications, petroleum coke is categorized into distinct types: raw (green) coke, which contains high levels of unrefined volatile matter; calcined coke, treated at extreme thermal conditions between 1200 and 1400 degrees Celsius for electrical engineering applications; and metallurgical coke, extensively utilized in the industrial synthesis of aluminum, silicon, and specialized ferroalloys.

Chemically and physically, petroleum coke is predominantly composed of carbon, accounting for 90 to 98 percent of its total mass. The remaining composition includes variable amounts of sulfur ranging from 0.5 to 7 percent, nitrogen, oxygen, and trace heavy metal compounds such as vanadium and nickel. Structurally, it exhibits a bulk density of 0.8 to 1.1 grams per cubic centimeter and a high combustion temperature window between 800 and 1000 degrees Celsius.

Evaluating the operational environment at the Fergana Oil Refinery through instrumental and laboratory measurements reveals that massive dust emissions occur during routine mechanical operations including coke crushing, material transportation, loading, and drying. Specifically, active material handling and transport zones exhibit airborne dust concentrations reaching between 7.2 and 8.0 milligrams per cubic meter, which significantly surpasses established sanitary and hygienic regulatory limits. Due to their fine respirable fraction and micro-disperse structure with particle sizes extending up to 8 micrometers, these airborne particles remain suspended for extended periods and penetrate deep into the workers' respiratory tracts. This continuous exposure triggers persistent inflammation of the mucosal membranes, substantially elevating the risk of developing chronic bronchitis, allergic rhinitis, pneumonia, and occupational bronchial asthma, while also imposing adverse systemic effects on the cardiovascular system.

### Conclusion

Despite its high energy density and critical strategic importance in modern industry, the production and processing of petroleum coke generate significant environmental and occupational hygiene challenges. The empirical findings from the Fergana Oil Refinery, which reveal excessive concentrations of airborne coke dust, clearly emphasize the urgent need for comprehensive technological modernization. To effectively mitigate these hazards, it is essential to implement closed-loop production systems, install advanced dust-filtering and ventilation units, and fully equip personnel with high-quality personal protective equipment. Addressing these critical safety measures is vital not only for reducing the incidence of occupational respiratory and systemic diseases among workers, but also for ensuring long-term ecological sustainability and environmental safety within the industrial region.

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